

Work Order ID 133786

Wednesday, June 17, 2015 2:52:20 PM

133786

U/R *N/A* *Q/N* Page 1

Item ID: D3884-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: ~~U/R~~ *N/A* *Q/N* Stop ***NS2***
 Item Name: Saddle, Inboard LH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: *MLS* Date: *JUN 17 2015* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3884	C

100	HAAS CNC VERTICAL MACHINING #1	0.00				<i>8</i>	<i>0</i>		DAS 20 9-89 15-07-29
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100
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Program Batch No. *133786*
 Double check by: *Q/N*
 1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

110	QC2- Inspect parts off machine FAI/FAIB	0.00				<i>8</i>	<i>0</i>		DAS 20 9-89 15-07-29
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110
 QC
 Quality Control
 Memo

Wednesday, June 17, 2015 2:52:20 PM

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Inboard LH

Start Date: 6/17/2015 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 6/17/2015 **Req'd Qty:** 8.00

g

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

OC

Memo

0.00

Quality Control

**DAS
14
9-89**

15/08/10

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 133786

Wednesday, June 17, 2015 2:52:20 PM

133786

Page 3

Item ID: D3884-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Saddle, Inboard LH
Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** N6131545 ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: 9:45 OVEN TEMPERATURE: 320°C FINISH TIME: 10:15	0.00 0.00				8x	9	11	LL 6/17/15
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(2)			DAS 38 9-89 AUG 14 2015

Work Order ID 133786

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133786

Page 4

Item ID: D3884-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Saddle, Inboard LH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
160	Identify as per dwg & Stock Location: ST404	0.00								
160										
Packaging	Memo	0.00				⑧	JA	AUG 14 2015		DAS 28 9-89
Packaging										
170	QC21- Final Inspection - Work Order Release	0.00								
170										
QC	Memo	0.00								
Quality Control										

MLS AUG 17 2015

Picklist Print

Wednesday, June 17, 2015 2:52:24 PM

Page 1

Work Order ID: 133786

133786

Parent Item: D3884-1

D3884-1

Parent Item Name: Saddle, Inboard LH

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017 *D6101-017* Saddle Billet		Manufactured	No				Each	4.0000	**	8		DAS 20 9-89	15-0727

Location

Loc Qty

Loc Code

MAT044

4

129915

4

133963

8

DART AEROSPACE LTD		Work Order: 133786
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.645	0.646	0.646	0.6455		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.612	0.614	0.613	0.613		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.0035	2.0036	2.0025	2.003		
J	0.140	0.175		0.142	0.143	0.143	0.1425		
K	1.265	1.285		1.2685	1.2686	1.2675	1.268		
L	0.115	0.135		0.122	0.123	0.123	0.123		
M	0.240	0.260		0.246	0.248	0.248	0.2485		
N	0.110	0.140		0.140	0.140	0.140	0.140		
O	0.240	0.260		0.250	0.250	0.247	0.246		
P	2.826	2.886		2.855	2.855	2.855	2.855		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.150	0.144	0.144	0.144		
S	0.720	0.780		0.765	0.765	0.765	0.765		
T	1.220	1.280		1.255	1.255	1.255	1.255		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.496	0.496	0.496	0.493		
Y	0.020	0.040		0.030	0.030	0.030	0.030		
Z	0.313	0.318		0.316	0.316	0.316	0.316		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.219	0.219	0.218	0.217		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		0.996	0.998	0.995	0.994		
AF									
Accept/Reject									

Measured by: 20 9-89	Audited by: 14 9-89
Date: 15-07-28	Date: 15/08/11

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 133786
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. B	Page 1 of 1

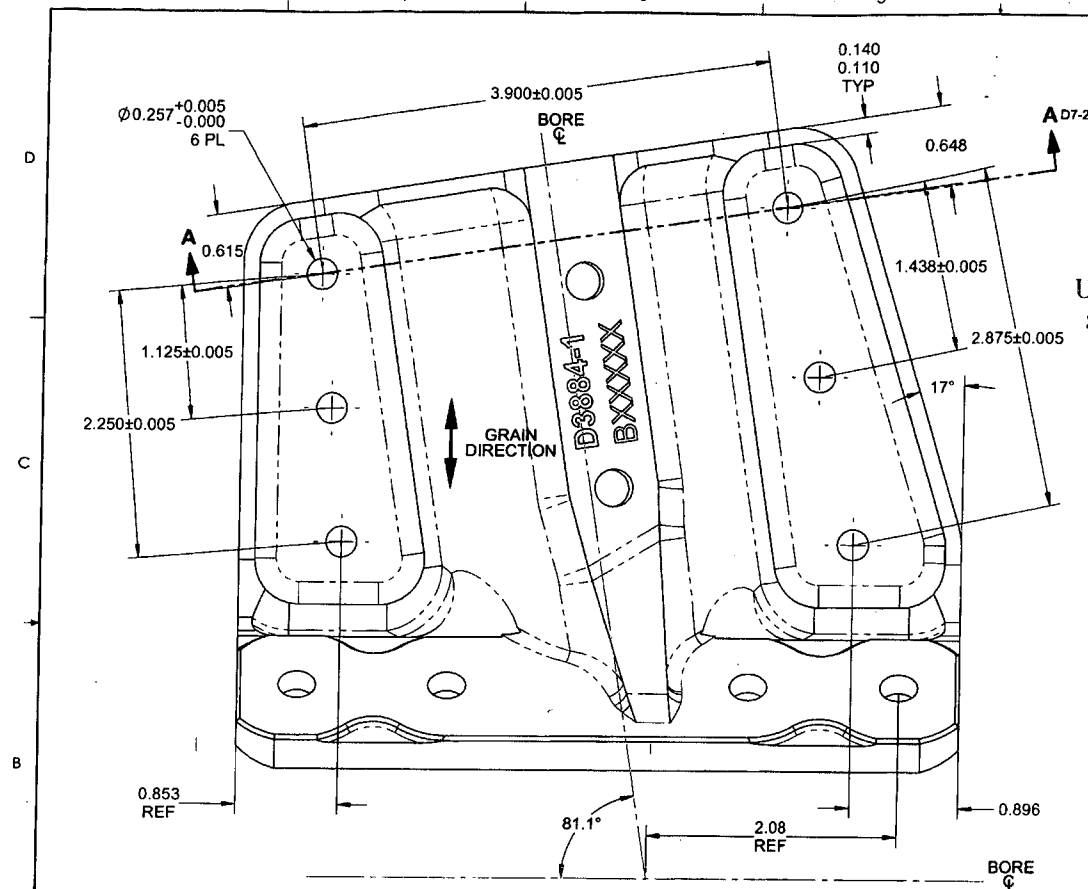
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.646	.646	.644	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.613	.612	.612	.612		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.003	2.002	2.003		
J	0.140	0.175		.142	.143	.142	.142		
K	1.265	1.285		1.2678	1.268	1.267	1.2678		
L	0.115	0.135		.122	.122	.123	.123		
M	0.240	0.260		.248	.249	.248	.248		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.247	.246	.248	.2475		
P	2.826	2.886		2.855	2.855	2.855	2.855		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.144	.143	.142	.142		
S	0.720	0.780		.765	.765	.765	.765		
T	1.220	1.280		1.255	1.255	1.255	1.255		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.495	.493	.494	.493		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.314	.314	.314	.314		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.217	.217	.217		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		.997	.996	.994	.994		
AF									
Accept/Reject									

Measured by:	20 9-89
Date:	15-07-28

Audited by:	DAS 14 9-89
Date:	15/08/11

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

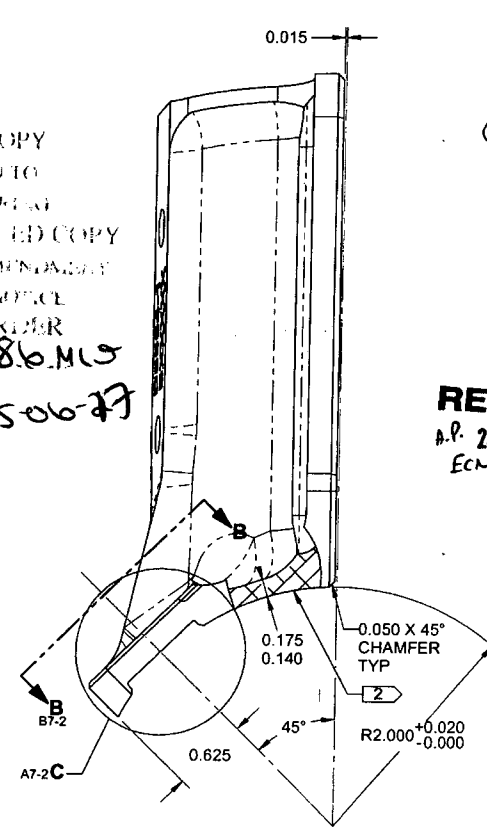


D3884-1 SADDLE, INBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-1-REVC.SLDPR"

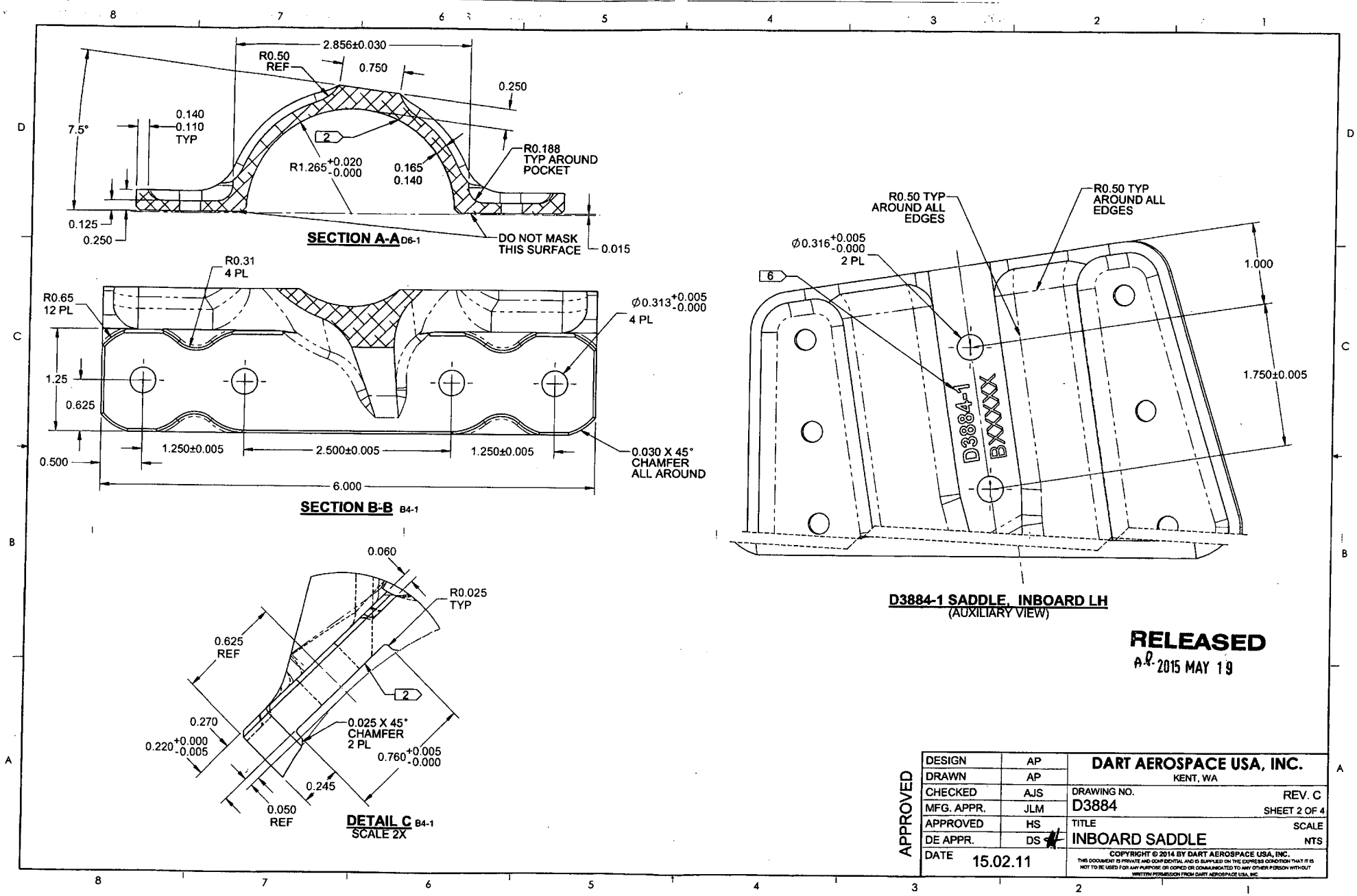
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WITHOUT NOTICE
WORK ORDER
NO. 133786.MC
1506-77



RELEASED
A.P. 2015 MAY 19
ECN15-575

C	GENERAL REDRAW & REMOVED UNNECESSARY DIMS; ADDED NOTE 9, REMOVED POWDER COAT FROM INSIDE SURFACE OF D3884-1/2, ADDED D3884-2 TO SHT 3 & 4.	AP	15.02.11
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE ZN C4-2; ADD R0.031 ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.185 ZN B7-1; ADD 0.615 ZN C8-1; ADD 0.648 ZN C4-1; ADD 0.250 ZN D6-2; ADD 0.060 ZN C2-2; 0.75 WAS 0.85 ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3884	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	INBOARD SADDLE	NTS
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

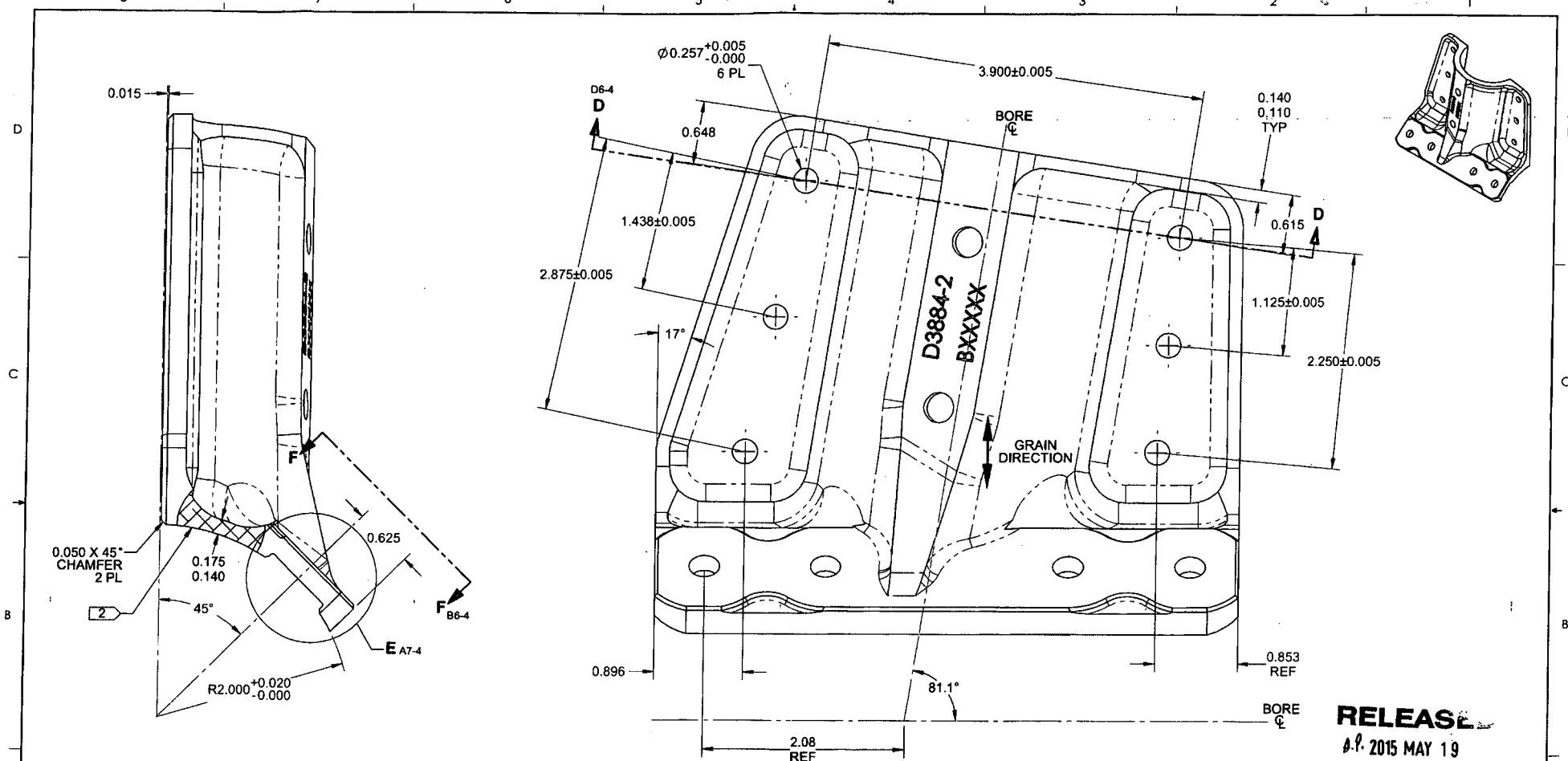
APPROVED



D3884-1 SADDLE, INBOARD LH
(AUXILIARY VIEW)

RELEASED
AR-2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC.	
	DRAWN	AP	KENT, WA	
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
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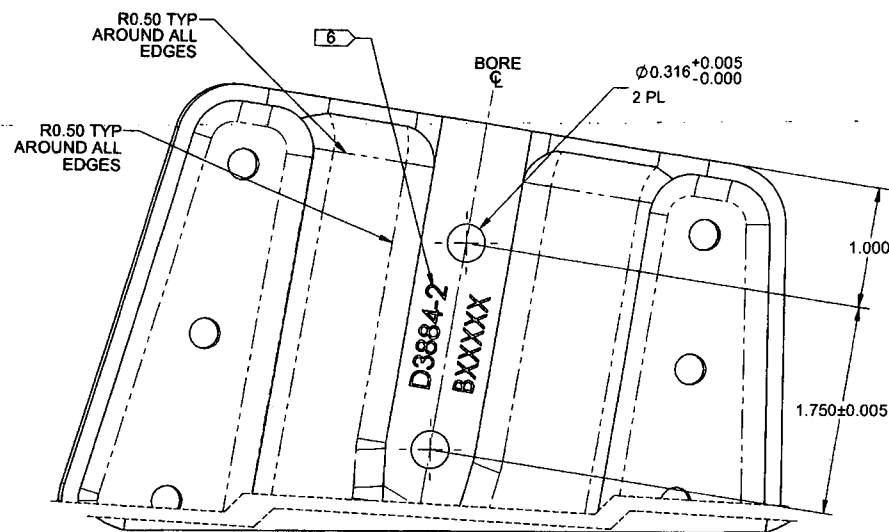
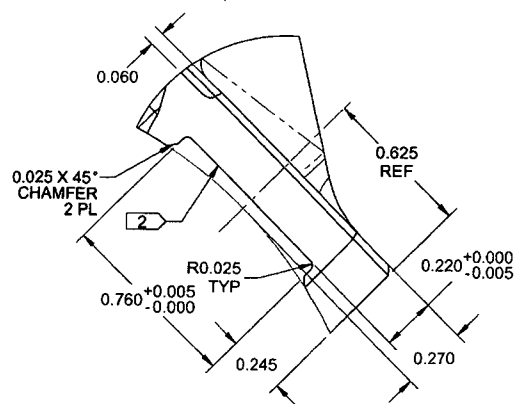
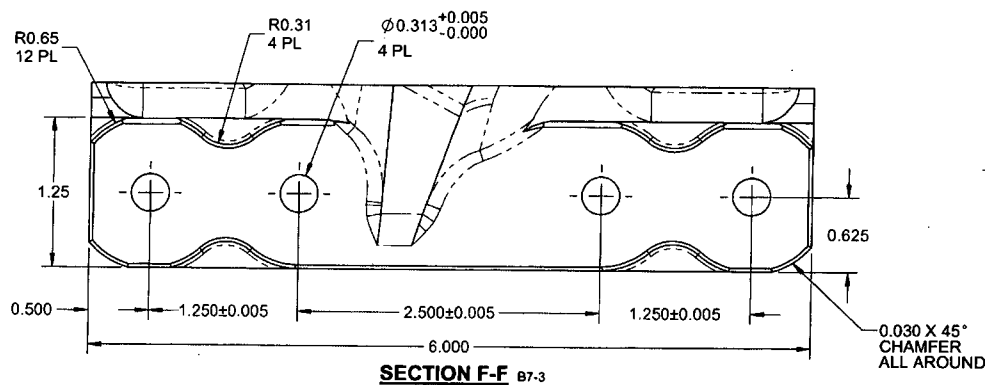
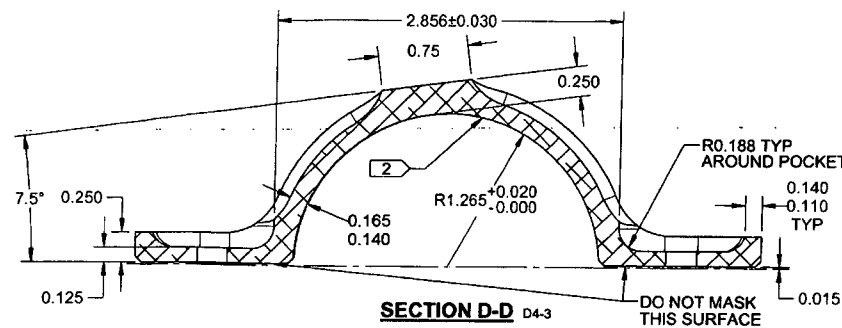
D3884-2 SADDLE, INBOARD RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REV.C.SLDPRT"

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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RELEASE
A.P. 2015 MAY 19



RELEASED

A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC.	
	DRAWN	AP	KENT, WA	
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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